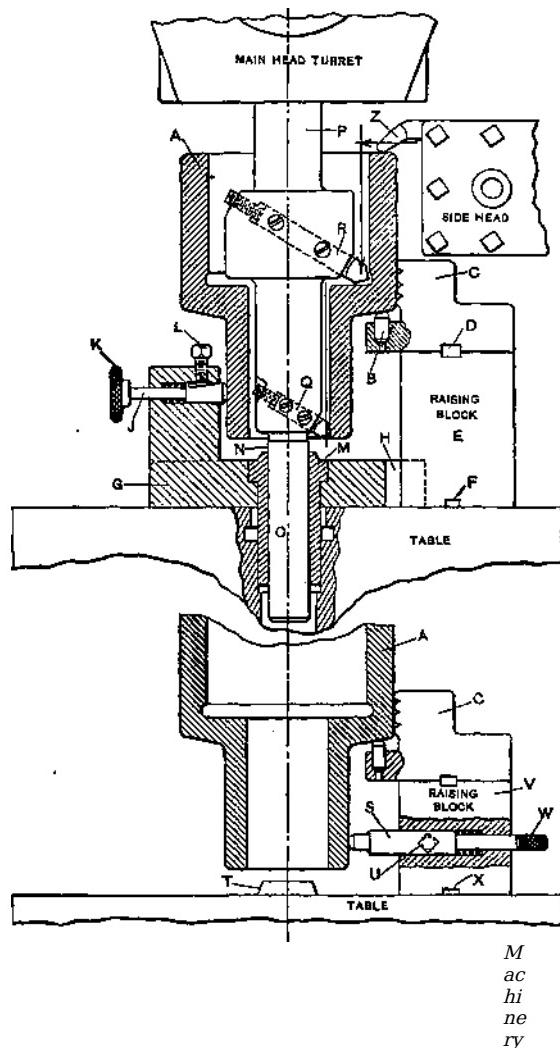


points *B* are set in projections of the upper jaws and the work rests on these points. A supplementary casting *G* is centered on the table by means of the hollow plug *M* which also acts



**Fig. 3. Original and Improved Methods of holding Large Hub Casting by Three-point Support**

as a guide for the boring-bar pilot *O*; and the upper part of this bushing is beveled as shown, but the edge of the hole is left sharp so that chips will not be drawn down with the bar and tend to destroy it together with the bushing. The base of